

Date: Monday, 05/05/2008 1:15:35 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET
<b>Job Number</b> :	39049		
<b>Estimate Number</b> :	10283		
<b>P.O. Number</b> :		<b>Part Number</b> :	D31991
<b>This Issue</b> :	05/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3199 REV B
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39016	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	20/05/2008
<b>Written By</b> :		<b>Qty:</b>	30 Um: Each
<b>Checked &amp; Approved By</b> :	JLM 08.5.05		
<b>Comment</b> :	Est Rev:C Removed Scribing 05-11-05 JLM Est Rev:D As per Rev B 06-11-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 0.1040 sf(s)/Unit Total : 3.1185 sf(s)

304/316 0.040" SHEET

Batch: 107909 LB 8-5-6

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: B

Prog Rev: B

Deburr if required

LB 8-5-6

LB 8-5-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

LB 8-5-6

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/05/06 + B5

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3199

SN 08/05/14 (35)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: \_\_\_\_\_ Date: 22/05/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>39049</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/05/20</u>	<u>12</u>	During inspection it was found that one part had a small notch cut in it from the water jet. R.C. Part moved at the end of water jet pulse.	<u>[Signature]</u>	Scrap and Destroy. <del>and replace</del> <del>B-B-8-5-6</del> no replace	<u>B</u> <u>8-5-6</u>	<u>S</u> <u>06/05/20</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>06/05/20</u>

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 1:15:35 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39049

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count  
08/05/14 (x.85)

7.0

POWDER COATING

POWDER COATING



M105642



(35X)

Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

11:58 AM

OVEN TEMPERATURE:

320 °F

FINISH TIME:

1:01 PM

M-L 08/05/15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



RL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-13 (13.5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

0233A

P-80/20 (35)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2008

Job Completion



MF 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

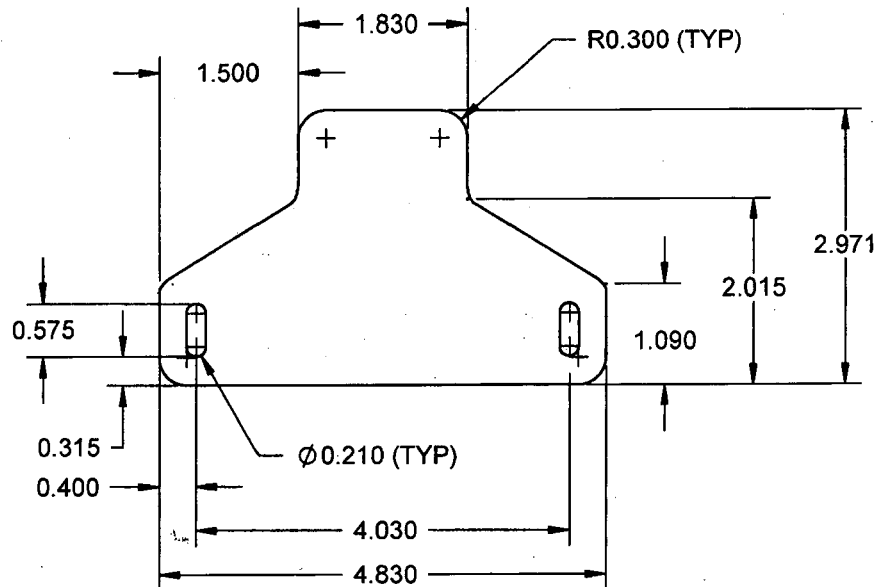
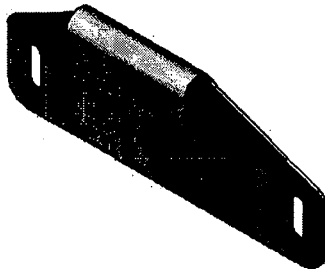
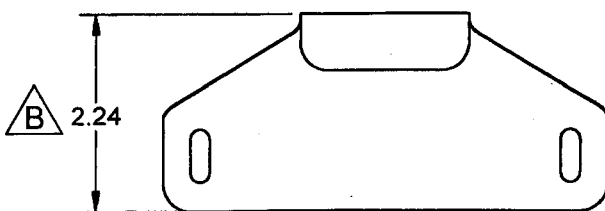
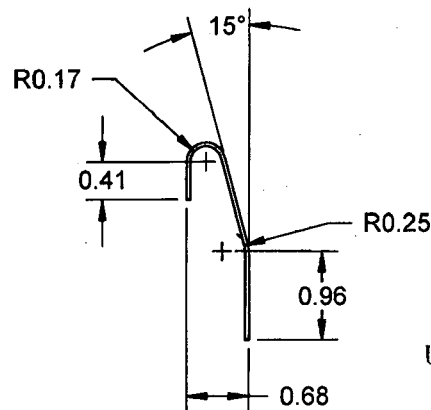
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>QD</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3199</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.01</b>	TITLE <b>BRACKET</b> SCALE 1:2		
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

**RELEASED***06.11.20***D3199-1 FLAT PATTERN****D3199-1 BRACKET**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39049

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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